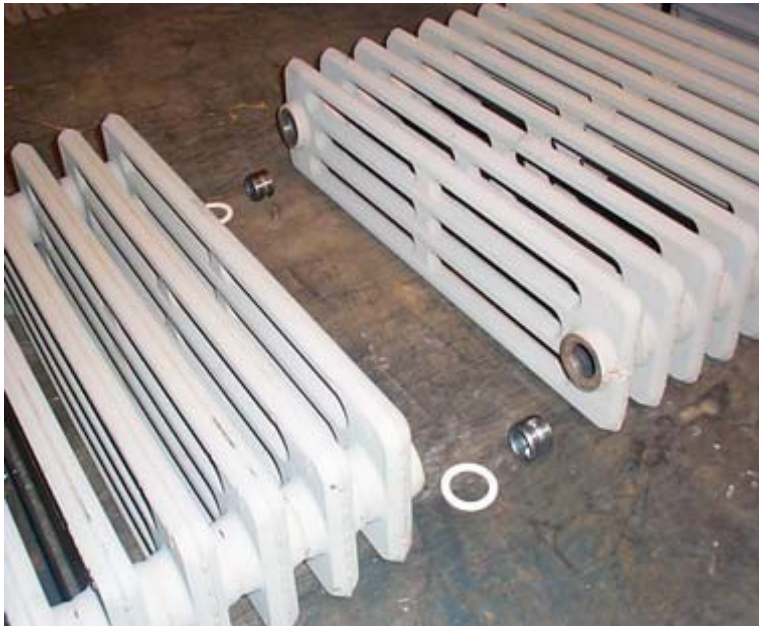




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Place the radiator sections to be joined onto a clean, firm and flat surface, ensuring that the machined faces and internal threads are perfectly clean. Each radiator section has right-hand threaded connections at one end and left-hand threaded connections at the other. The nipples have one end left-handed and one end right-handed. For correct assembly you will need to identify the orientation of the connections on the radiator assemblies.

For each pair of sections to be joined there are 2 joints to be made. Each joint requires one connection nipple and one gasket. A nipple key and tommy bar are used to rotate and then tighten the connections



Screw in a pair of nipples to one end of the radiator assemblies.  
Only screw in by one turn. Do not screw in fully.  
Place a gasket over each nipple, approximately at the mid-point of the nipple.

Do not apply any jointing paste or tape (e.g. Boss White, PTFE, hemp etc) to the gasket, threads of the nipples, or the radiator.



Gently slide the second radiator assembly next to these nipples, ensuring that the thread orientations are correct.

Lay the nipple key over the top of the radiator so that the head is in line with the nipples to be turned. Mark the key so that when it is inserted, the head engages inside the nipple. Slide the key in from the open end of the waterway until it engages into the nipple that is to be tightened. Check that the end of the key engages in the internal lugs inside the nipple.



By turning the nipple key, rotate the nipple so that it pulls the 2 radiator assemblies together. At this stage only rotate the nipple by one turn.

Repeat this operation with the other nipple. Repeat both of these operations in turn, gradually pulling the 2 radiator assemblies together, ensuring they are kept parallel.

Finally, tighten the joints to compress the gaskets. Ideally a tightening torque of 200 Nm (20 kgf-m, 150 lbf-ft) should be applied.

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